

Work Order ID 139357

Wednesday, November 25, 2015 11:23:26 A

139357

Page 1

Item ID: 647.3804

Revision ID:

Item Name: Lower Cutter Assy High

Start Date: 11/25/2015 Start Qty: 2.00

Required Date: 11/25/2015 Req'd Qty: 2.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: MF Date: 15-11-25 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
647.3800	n/c

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

120

0.00

120

Small Fab

Memo

0.01

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: M133436
exp. date: 07/17

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.00

Quality Control

Lx 15/11/26 DAS 36 9-89

2 DAS 38 9-89
DEC 07 2015
P.T.O.

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only ☐

Work Order: <u>139357</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>647-3804</u>		Rework ☒		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-5492</u>		Scrap ☐		Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐	
Date: <u>15-12-07</u>	Step #: <u>120</u>	QTY Effective: <u>1</u>				MRB (QSI042) Approval DAS 9 9-89 <u>15-12-07</u>	
Description Work Order Deviation				Disposition			
change 3 rivet there no good rivets too much crushing				change 3 rivets there no good change rivets Rivets # <u>MS 20470 ADG-12</u> Batch # <u>M127304 SP x 2</u>			
				Completed By DAS 41 <u>15-12-7</u> 9-89			
				Lead hand / Supervisor Approval Verification DAS 38 9-89 DEC 07 2015			
				QC / QA Coordinator Approval DAS 38 9-89 DEC 07 2015			
Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☒	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☒	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☒	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER <u>change rivets</u>					
Misidentified ☐	Past Due ☐						

Work Order ID 139357

139357

Page 2

Wednesday, November 25, 2015 11:23:26 A

Item ID: 647.3804 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lower Cutter Assy High
 Start Date: 11/25/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 11/25/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>CCF 027</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER IAW MPP-120***								DEC 07 2015
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							DEC 08 2015
Quality Control									

MCS DEC 07 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist-in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Wednesday, November 25, 2015 11:23:25 AM

Page 1

Work Order ID: 139357

139357

Parent Item: 647.3804

647 3804

Parent Item Name: Lower Cutter Assy High

Start Date: 11/25/2015

Required Date: 11/25/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.10.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701		Manufactured	No			110	Each	6.0000	1	2			DAG 6 9.00
646 9701									**				
Cutter Sub Assembly													

Location	Loc Qty	Loc Code
cck012	6	
127683	1	
127684	3	
138414	2	

NAS1149FN832P Purchased No 110 Each 461.0000 6 12

NAS1149FN832P

Washer

Location	Loc Qty	Loc Code
ST262	461	
M133316	461	

MS21042L08 Purchased No 110 Each 923.0000 3 6

MS21042L 08

Nut

Location	Loc Qty	Loc Code
CA	101	
m129682	101	
GA	56	
m133134	56	
ST303	697	
m133483	697	
ST304	69	
m128401	58	
m131317	11	

NOV 25 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Picklist Print

Wednesday, November 25, 2015 11:23:25 AM

Page 2

Work Order ID: 139357

139357

Parent Item: 647.3804

647 3804

Parent Item Name: Lower Cutter Assy High

Start Date: 11/25/2015

Required Date: 11/25/2015

Start Qty: 2.00

Required Qty: 2.00

MS27039-08-19

Purchased

No

110

Each

585.0000

3

6

MS27039-08-19

Screw

Location

Loc Qty

Loc Code

cck007a

400

m133483

400

GA

137

m132930

96

m133077

41

ST276

48

m131317

48

647.3902

Manufactured

No

110

Each

8.0000

1

2

647 3902

Lower Deflector Assembly, High

Location

Loc Qty

Loc Code

cck052

8

124694

8

NOV 25 2015

NOV 25 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

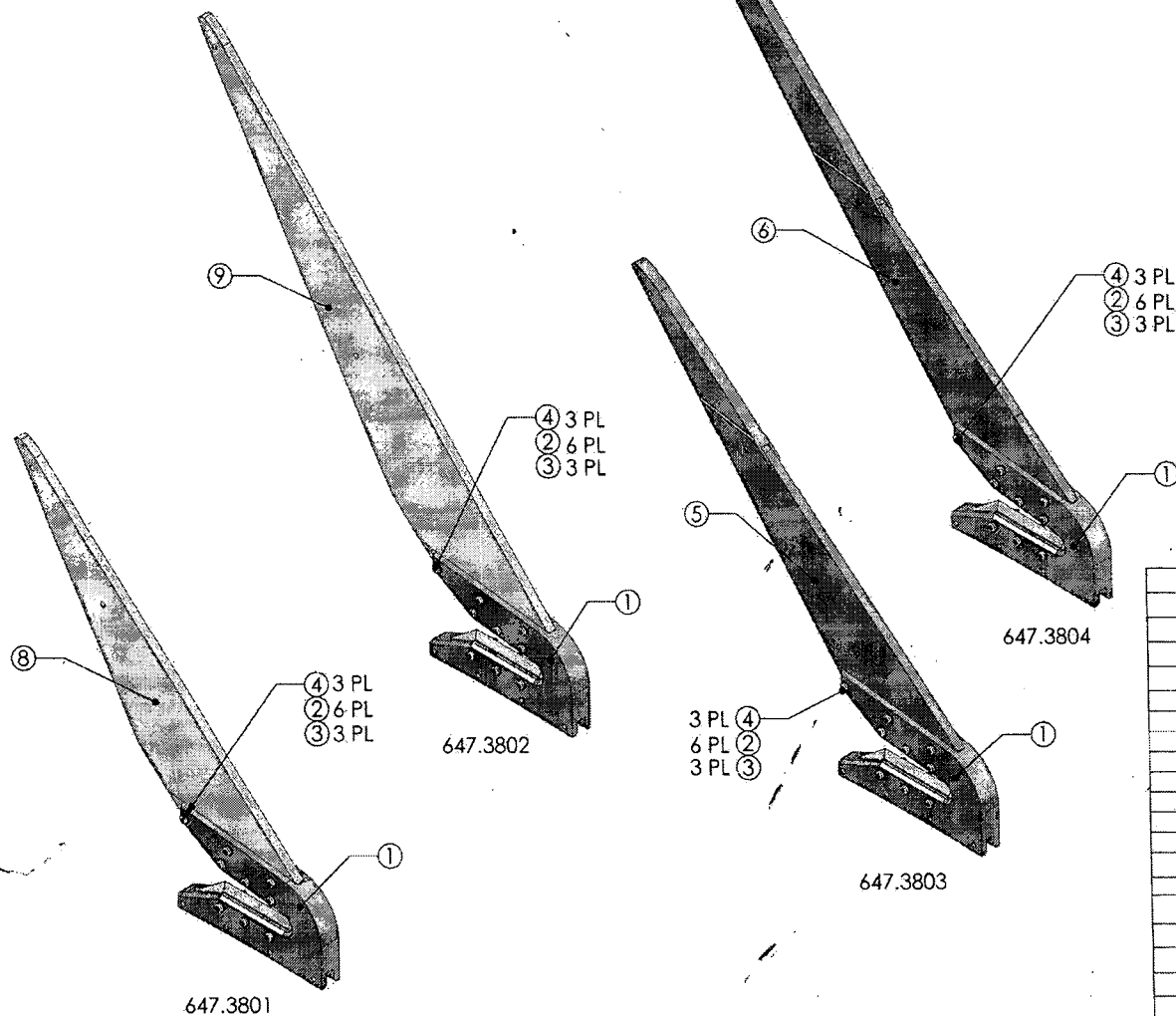
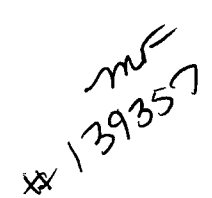
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

NOTES:

1. IDENTIFY JAW MPP-120
2. APPLY F/N 9 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 5, 6, 7, & 8 UPON ASSEMBLY

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVE
	LAST PROTOTYPE REVISION: PR1		JUC
171C	INITIAL RELEASE	00-10-2008	P. B. B. B.



				1		9	647.3911	212 UPPER DEFLECTOR		
				I		8	647.3910	412 UPPER DEFLECTOR		
	A/R	A/R	A/R	A/R		7	601.2045	RTV. LOCITE 598		
	1					6	647.3902	LOWER DEFLECTOR ASSY HIGH		
		1				5	647.3901	LOWER DEFLECTOR ASSY LOW		
	3	3	3	3		4	601.2765	SCREW	M527D39-081P	
	3	3	3	3		3	601.1541	LOCKNUT	M521D42-08	
	6	6	6	6		2	601.2764	WASHER	EIAS1149FNBSZP	
	1	1	1	1	1		646.9701	CUTTER SUB ASSY		
							647.3804	LOWER CUTTER ASSY HIGH		
							647.3803	LOWER CUTTER ASSY LOW		
							647.3802	212 UPPER CUTTER ASSY		
							647.3801	412 UPPER CUTTER ASSY		
	.3804	.3803	.3802	.3801	FIND #		PART #	DESCRIPTION	MATL	SPEC.
QTY					PARTS LIST					
NEXT ASSY [S]					ORIGINAL DATE UNSPECIFIED DATED BY DRAWING SET J JACOBSON TO BARRY PURCHASER APPROVAL DATE BY OFFICIAL CONTRACT NO. THIS IS OTHERWISE SPECIFIED EXCEPTED PART NUMBER FOR PARTIAL QUANTITY QUANTITY ORDERED = QTY SPECIFIC DECIMALS ONLY ENTER IN "X" B					
647.3700										
					APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300					
					CUTTER ASSY					
					SIZE CAGE CODE DWG NO B 07/MZ6 647.3800 SCALE NONE SHEET 1 OF 1					

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
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